

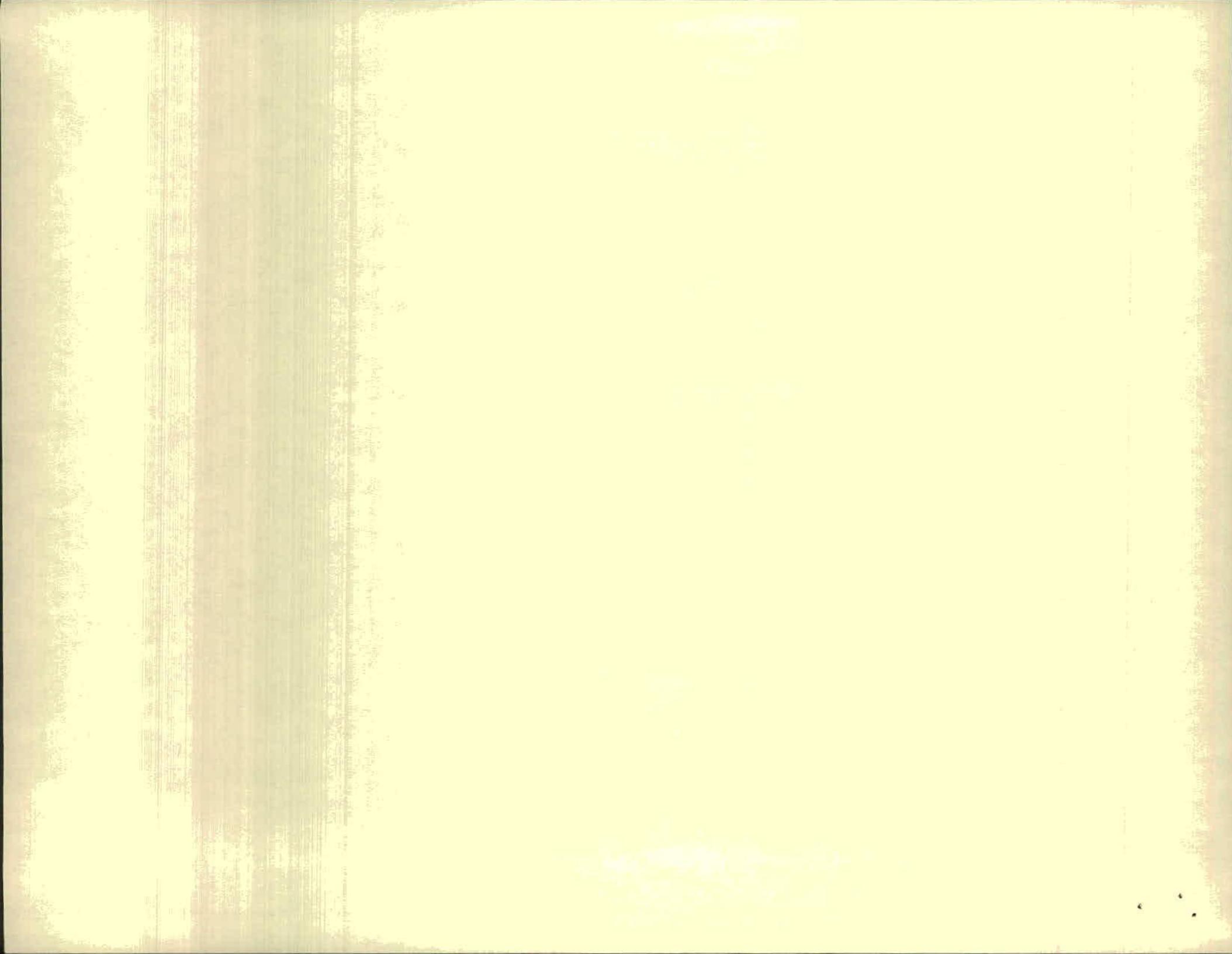
51
SPLIT

DART AEROSPACE LTD	Work Order:	21966B
Description: 3" Skidtube Heavy "I Beam"	Part Number:	D2600-7-140
Dwg: D2600 Rev. D1	Qty:	2293 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	DR	01.11.25	2293
2	PG	Issue P/O: 700796 a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 140" long g) Caradon Indalex Tool # MS-18872 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	W	04.11.25	93
3	RG	Receive and Inspect for transit damage Ensure certification is attached	CJ	05/01/07	49
4	QC6	Inspect dimensions as per Dwg D2600 Check Pull test as per Dwg D2600 for compliance page attached. Check hardness with Webster tester	DR	05/02/07	49
5	ST	Identify and Stock	DR	05/02/07	49
6	AC	Cost / part: 36.98	SAC	05.02.03	15
7	DC	Close W/O 36.98 Inspect Level 21	DR	05.02.04	49

Rev	Date	Change	Revised By	Approved
A	04.11.25	New Issue	KJ/RF	RF

RELEASED
04.11.25 RF





DESIGN <i>DJH</i>	DRAWN BY <i>DS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>DS</i>	DRAWING NO. D2600 REV. D SHEET 1 OF 5
DATE 98.08.20	TITLE EXTRUSION	SCALE 1:1

RELEASER
18 08 25 DS

A	97.01.21	NEW ISSUE
B	97.09.09	CHANGE MATERIAL SPEC.
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.
D	98.08.20	INCREASE MIN. UTS TO 40 KSI
DI	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>+ GP</i>

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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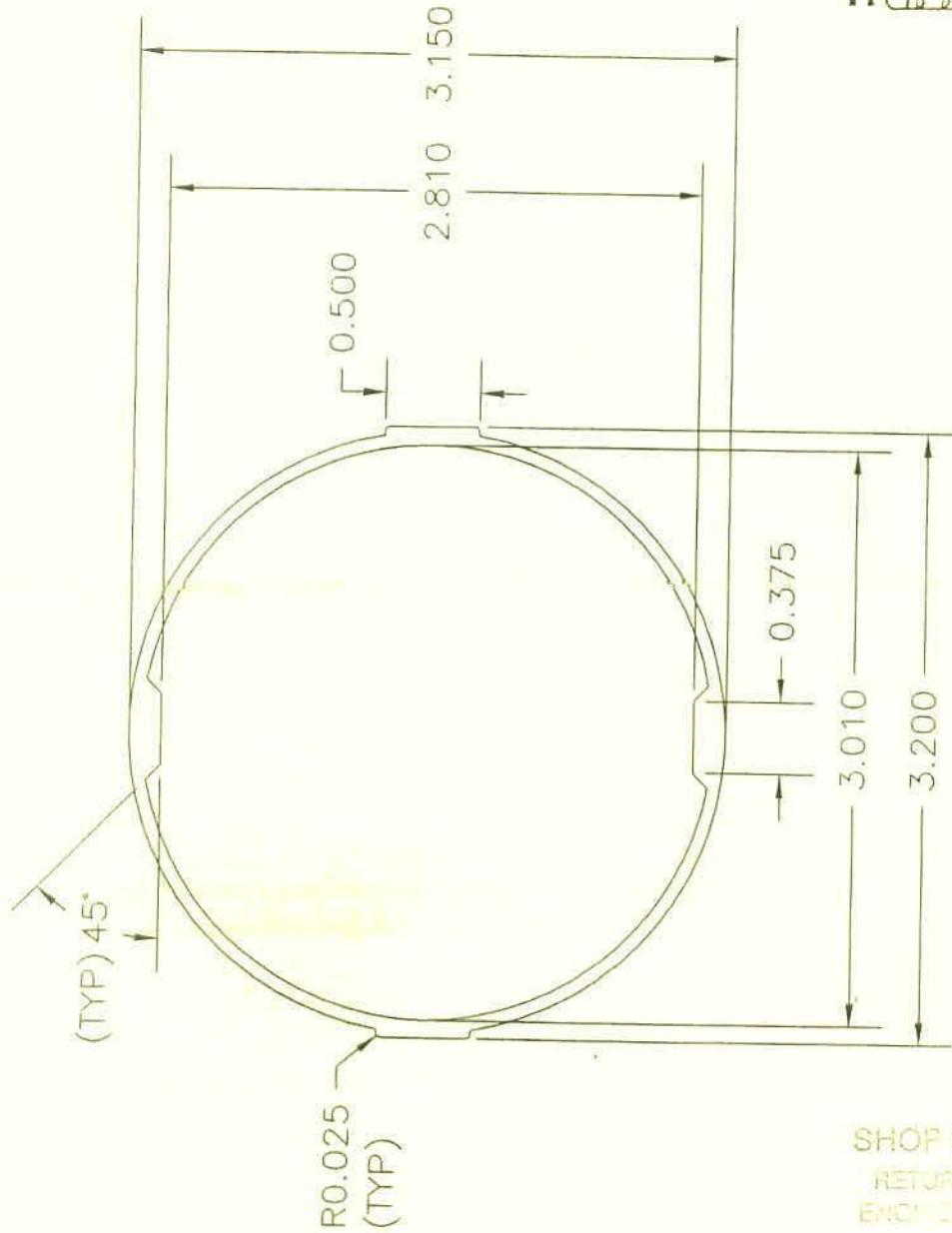
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AMENDMENT
NOTICE

IN ORDER
NO. 21966



DART

DESIGN <i>BB</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JH</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
[98 8 25 DS]D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG D2600-1-160 IS 160" Long)

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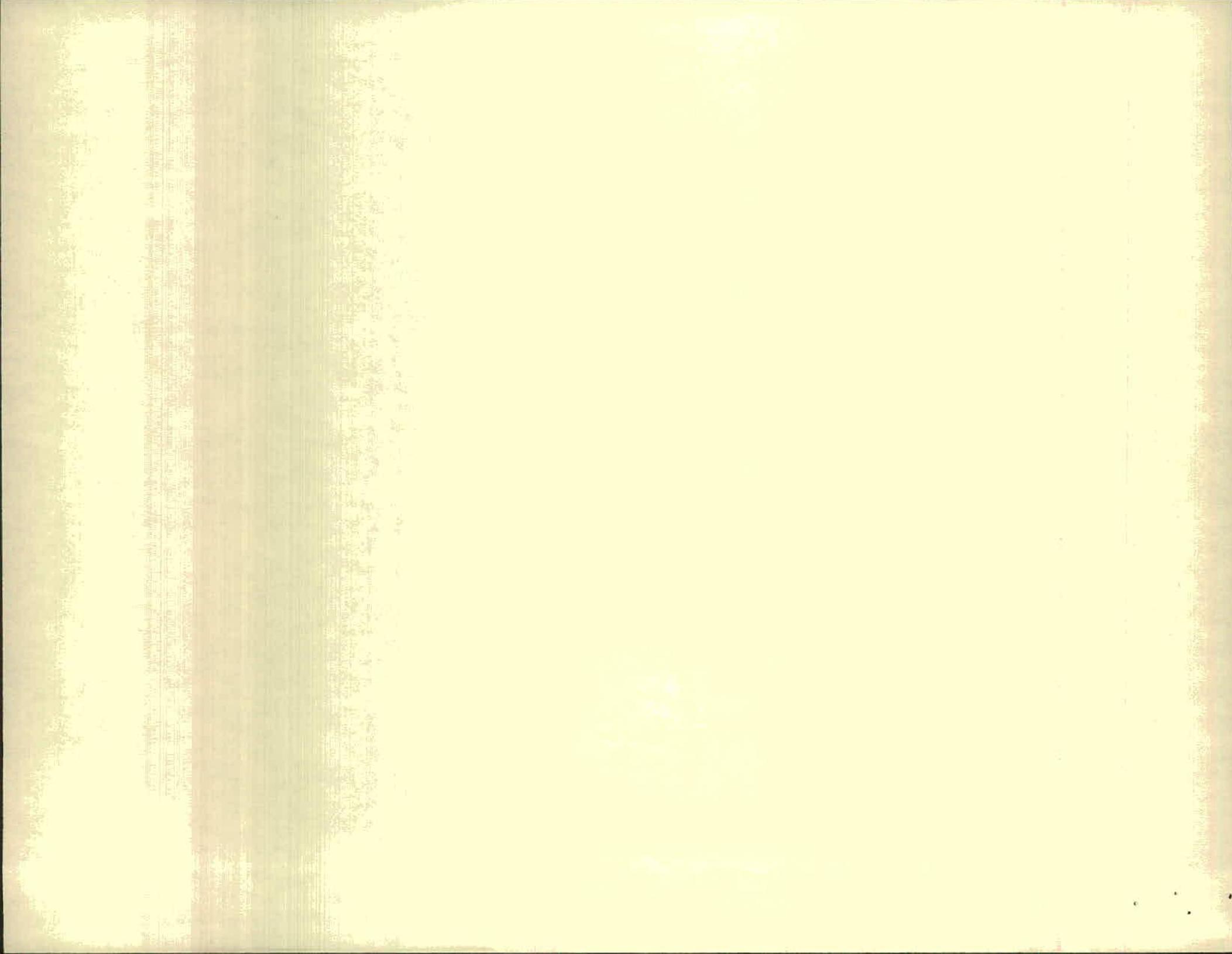
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SOL. CETING DRAFT



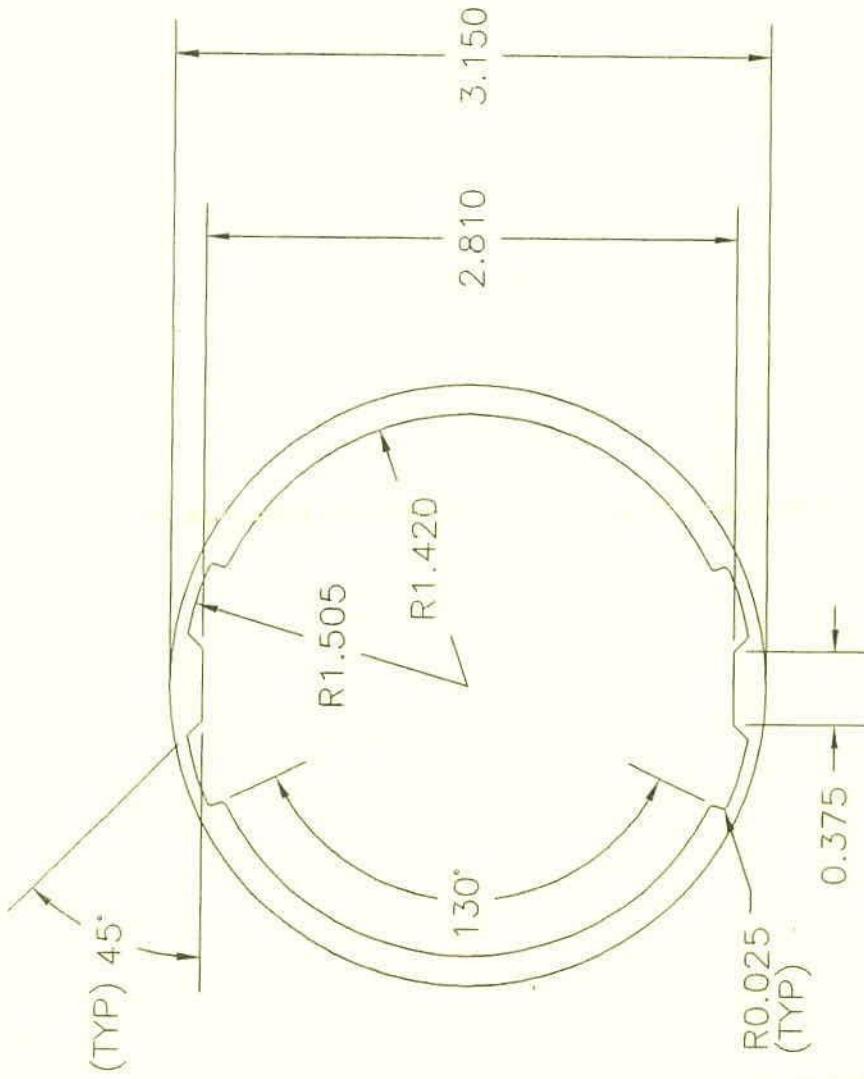
21966



DART

DESIGN <i>DM</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS
(98.8.25 DS)

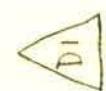
D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
 OR BON L DIE # Q97122 (PREFERRED CHOICE)

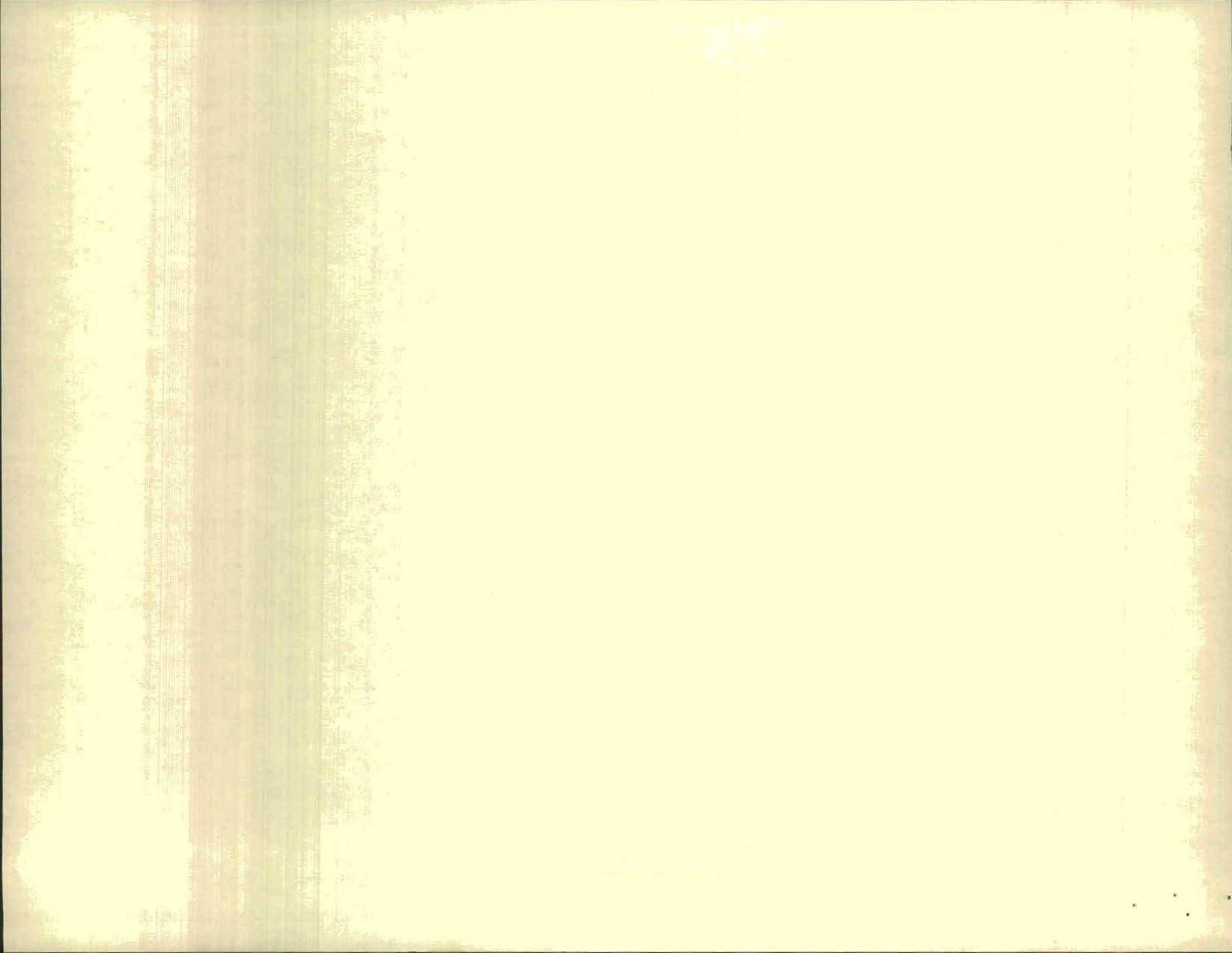
Part number is D2600-3-XXX where XXX is cut length in inches (Eg. D2600-3-120 is 120" long)

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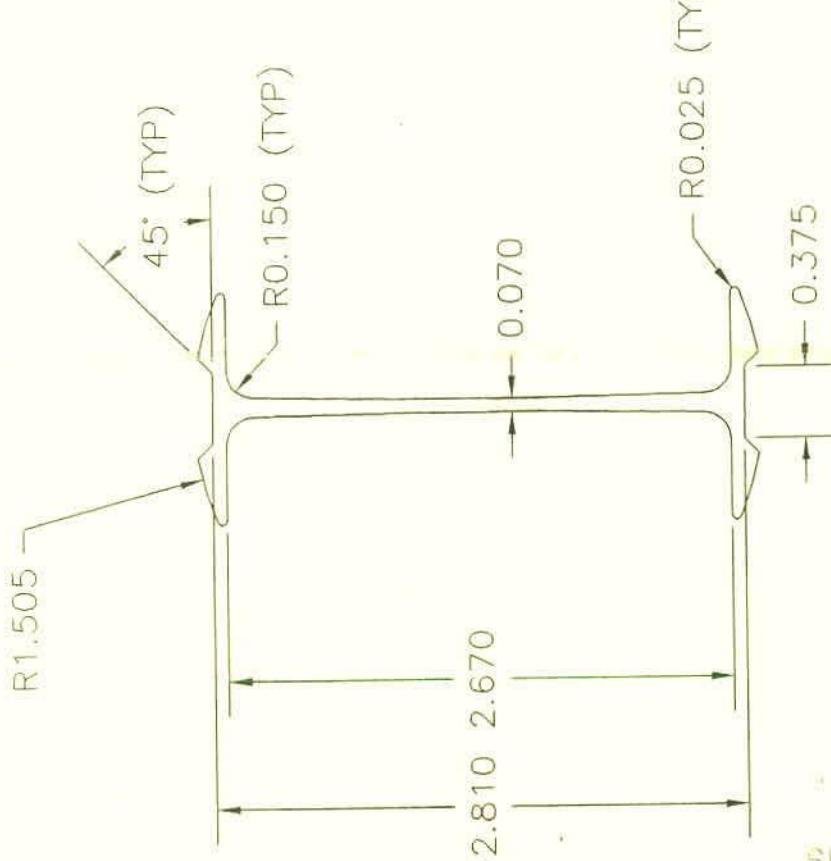


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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
[98 8 25 DS]D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART Number IS D2600-5-XXX WHERE XXX IS Cut LENGTH IN INCHES
(Eg. D2600-5-108 IS 108" LONG)

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SURREY AVIATION INDIMENT
DISCLAIMER NOTICE

WORK ORDER

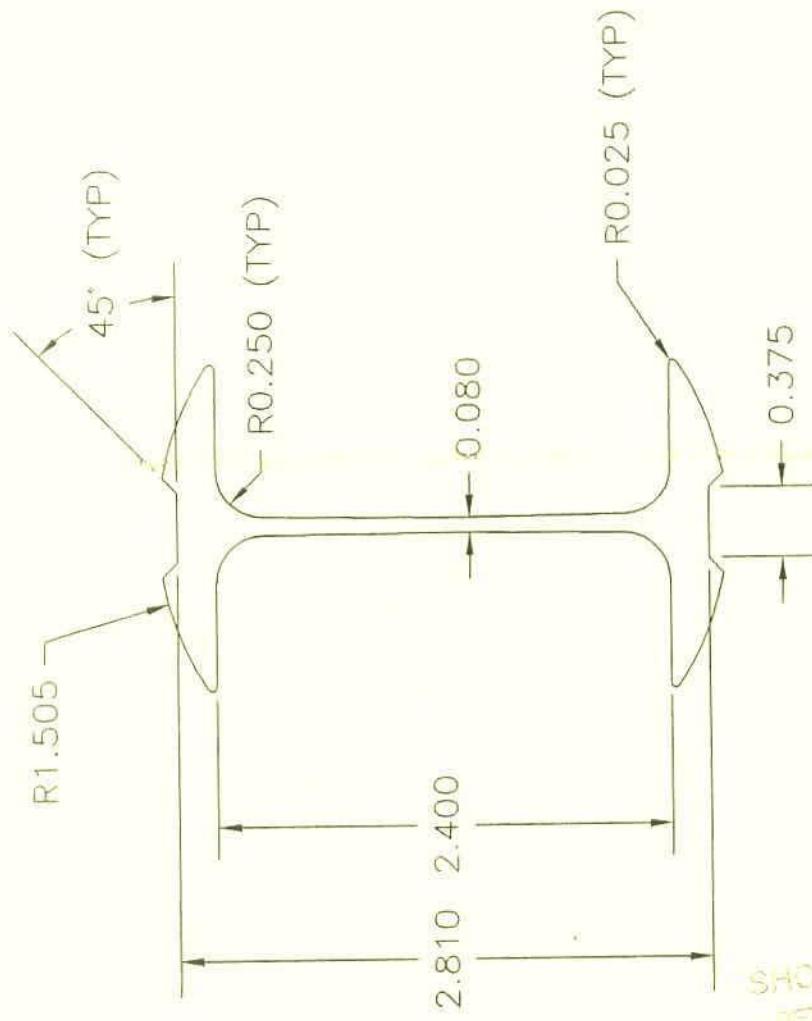
NO. 21966





DARTCOPY IS
DRAFT

DESIGN <i>DK</i>	DRAWN BY <i>DS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # M5-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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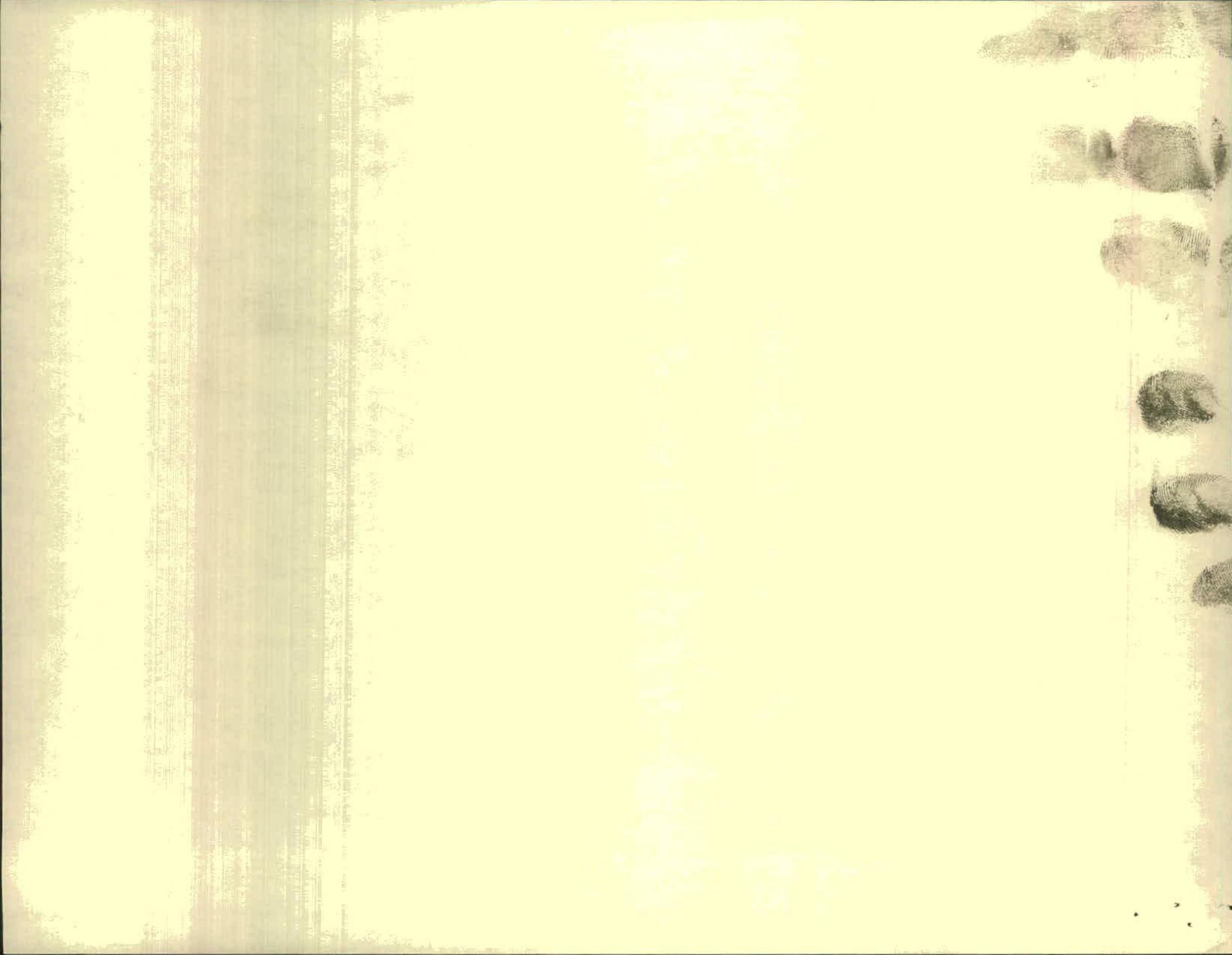
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AMENDMENT

NOTICE

WORK ORDER

NO. 21966





325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**
 Adresse / Address : **1270 ABERDEEN STREET**
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : **4113326**

bon de commande / Purchase order # : **2007196**

de matrice / Die # :MS 18872 Description : D-2600-7 Heavy Duty Web

Alliage & trempage / Alloy & temper : **6061-T6**

de coulée / Cast # : **4123301-B**

de contrôle / Control # : **73756-3**

Composition chimique typique / Typical chemical composition :

Si:0.50-0.70/ Fe:0.13-0.25/ Cu:0.15-0.25/ Mn:0.10max / Mg:0.80-1.00 / Cr:0.04-0.14 / Zn:0.05max / Ti:0.05max

Dureté Rockwell E / Rockwell E Hardness : **95 HRE**

	Min.requis Min.required	Résultat actuel Actual results
Contrainte élastique Yield stress (psi)	35 000	41 574
Tension ultime Ultimate stress (psi)	38 000	44 809
% élévation dans 2" % elongation in 2"	8	9

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par l'Association de l'Aluminium ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2005/01/05

Alain Gignac
Technicien de la qualité
Quality technician

